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71 Applicant: D. Drukker & Zn. N.V.
 Sarphatikade 12
 NL-1017 WV Amsterdam(NL)

72 Inventor: Seal, Michael
 Guido Gezellestraat 5
 NL-1077 WN Amsterdam(NL)

72 Inventor: Berkhout, Franciscus Marinus
 Bulzerdhorst 24
 NL-5431 LW Cuyk(NL)

74 Representative: de Vries, Johannes Hendrik
 Fokke et al,
 Octrooibureau Los en Stigter B.V. P.O. Box 20052
 NL-1000 HB Amsterdam(NL)

54 Method for making microsurgical suture needles and microsurgical suture needles obtained by this method.

57 Microsurgical suture needles are made by providing a precious stone plate (3) with main surfaces extending obliquely with respect to the longitudinal rib. A metal shank (2) is provided with an end face extending correspondingly obliquely with respect to its longitudinal axis. The precious stone plate is attached with one main surface on the oblique end face of the metal shank. The other main surface of the precious stone plate is ground and provided with a sharp tip (6) and cutting edges (7).

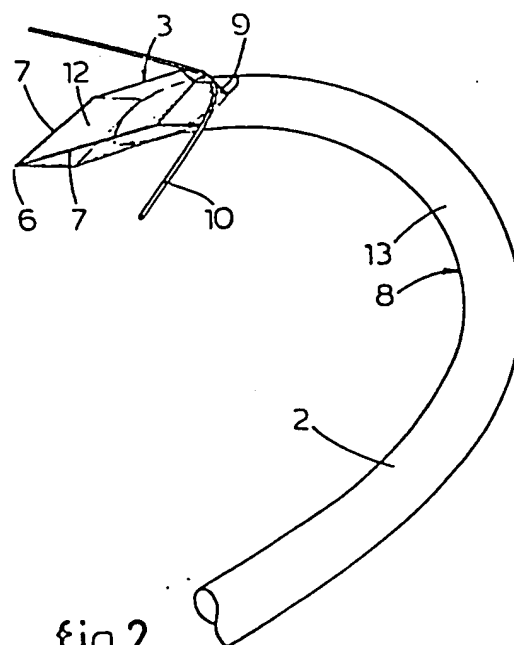


fig.2

Method for making microsurgical suture needles and microsurgical suture needles obtained by this method.

The invention relates to a method for making microsurgical suture needles and to a microsurgical suture needle obtained by this method.

The usual microsurgical suture needles are made completely from metal. In particular in eye surgery the suture of wounds by means of such a suture needle is an operation which should be done with the utmost care as uncontrolled movements may have serious consequences.

The invention aims to provide a method for making microsurgical suture needles by which suture needles are obtained which are easier to handle by the surgeon.

According to the invention the method is characterized in that a precious stone plate is formed with main surfaces extending obliquely with respect to the longitudinal rib, an end face extending correspondingly obliquely with respect to the longitudinal axis being ground at one end of a metal shank, on which the precious stone plate is attached with one main surface on the oblique end face of the metal shank, whereafter the other main surface of the precious stone plate is ground and provided with a sharp tip and cutting edges.

Thereby a suture needle can be obtained having a tip substantially sharper as compared to the known completely metal needles, and having cutting edges whereby the penetration capacity of the suture needle in the tissue is significantly increased. The pressure which has to be exerted on the suture needle in order to penetrate the tissue is thereby substantially less so that uncontrolled movements are reduced and the edges of the eye wound will deform less during the suture. Thereby the chance of losing intraocular fluid is reduced. Moreover the suture needle according to the invention produces smaller wounds so that the recovery is affected favourably and the deformation of the eyeball will be less.

Preferably a recess is cut out of the main surface of the precious stone plate to be attached to the metal

shank. With a suture needle made in this manner a special suture method can be used whereby it is possible to hold the suture needle in a pair of tweezers and pick up the thread without the necessity of passing the needle completely through the wound as is necessary in the usual suture methods. Moreover in this case it is also possible to use the suture needle several times. The suture needle can be reground after some time.

The microsurgical suture needle according to the invention is characterized by a metal shank with a curved end part and a precious stone plate attached to the end face thereof extending obliquely with respect to its longitudinal axis, said precious stone plate having main surfaces extending correspondingly obliquely with respect to its longitudinal rib, and said precious stone plate being provided with a ground tip and cutting edges.

The invention will hereinafter be further explained by reference to the drawings in which some embodiments of the suture needle according to the invention are shown.

Fig. 1 is a perspective view of an embodiment according to the invention of the suture needle connected with a suture thread.

Fig. 2 is a perspective view of the end portion of a suture needle according to the invention which is very suitable for repeated use.

Fig. 3 is a side view of the suture needle according to fig. 2.

Fig. 4 is a perspective view of a third embodiment of the suture needle according to the invention also connected with a suture thread.

Referring to fig. 1 there is shown a perspective view of a suture needle 1 consisting of a metal shank 2 and a diamond plate 3 attached to one end thereof. The other end 4 of the shank 2 is permanently connected with a suture thread 5.

In the embodiment shown in the drawings the cross-section of the metal shank 2 varies from substantially circular at the end 4 to substantially rectangular towards the diamond plate 3. The cross-section of the shank may

however also be continuously circular or rectangular whereas other cross-section shapes are also possible.

The diamond 3 has a sharp tip 6 and cutting edges 7. As the suture thread 5 is permanently connected with the suture needle 1, the suture needle shown in fig. 1 is only suited for use once.

Fig. 2 and 3 show a suture needle 8 which is especially suited for use more than once. The suture needle 8 like the suture needle 1 comprises a metal shank 2 and a diamond plate 3 attached to one end thereof. This diamond plate 3 in this case is provided with a recess 9 in which a suture thread 10 can be received. Thereby the suture thread 10 can be drawn through the tissue together with the suture needle 8 in order to close a wound. The suture needle 8 can be held constantly in the pair of tweezers without the necessity of releasing and regrasping the suture needle several times during making the suture.

The suture needles 1 and 8 described are made as follows. From a diamond plate obtained in a usual manner little square logs are made with a cross-section of 0,2 x 0,2 mm, for example. From such logs the diamond plates 3 are cut with main surfaces extending obliquely with respect to the longitudinal rib of the log at an angle of 60°. The thickness of the diamond plates 3 amounts for example upto about 0,22 mm. In order to form the recess 9 a little section of for example 50 x 50 μ is cut out parallel to a main surface. This main surface of the diamond plate 3 is metalized with a titanium-copper-silver or gold-tantalum alloy in a manner known per se.

Thereafter a metal shank with a diameter of 0,2 mm, for example, and with the desired length is cut from a wire. At one end of the metal shank 2 so obtained an end face 11 is ground which also extends obliquely with respect to the longitudinal axis of the shank at an angle of 60°. This oblique end face 11 is also metalized with a titanium-copper-silver or a gold-tantalum alloy.

Thereafter, both metalized faces of the shank 2 and the diamond plate 3 are attached to each other by placing said metalized faces against each other at elevated tempera-

ture, whereby the metalized layers diffuse into each other and a strong connection is formed. The superfluous material of the titanium-copper-silver or gold-tantalum alloy is removed. Subsequently the suture needle 1 or 8, respectively
5 is clamped in a grinding holder so that the free main surface 12 can be ground in order to provide the diamond plate with a sharp tip and cutting edges. Finally, the metal shank 2 is provided with the desired bend 13.

Of course the strength of the connection obtained
10 can be controlled.

Fig. 4 shows a suture needle 14 mainly corresponding with the suture needle 1 shown in fig. 1. The manufacturing of the suture needle 14 mainly takes place in the above-described manner, wherein however a usual suture needle with-
15 out diamond plate forms the starting point.

The suture needle 14 is provided with a triangular diamond plate 15 obtained by cutting through a diamond plate 3 made in the described manner along the short diagonal parallel to the longitudinal rib. In the suture needle 14 shown
20 one of the main surfaces of the triangular diamond plate 15 is bevelled but this is not necessary. The tip 16 of the diamond plate 15 can be reground by making a small facet on the tip.

By means of the described method microsurgical suture needles are obtained with very sharp tips and cutting
25 edges whereby the penetration capacity of the suture needle in tissue is very good. The pressure which has to be exerted on the needle during suturing a wound in order to penetrate the tissue is thus low, so that uncontrolled movements
30 are obviated. The suture needles described here are especially suited for eye surgery, wherein during suturing an eye wound the edges will deform less and the chance of losing eye fluid is significantly decreased. Moreover the described suture needles produce smaller wounds so that the recovery
35 is favourably affected and the deformation of the eyeball will be less.

The described suture needles are suited for repeated use and can be reground, if required.

It is noted that said oblique faces of the diamond

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and the shank may also extend obliquely at a different angle than 60°.

Although in the above embodiments diamond plates are used it is also possible to use different types of precious stone such as ruby. However, diamond is to be preferred.

The invention is not restricted to the above-described embodiments which can be varied in a number of ways within the scope of the invention.

1. Method for making microsurgical suture needles, characterized in that a precious stone plate is formed with main surfaces extending obliquely with respect to the longitudinal rib, an end face extending correspondingly obliquely
5 with respect to the longitudinal axis being ground at one end of a metal shank, on which the precious stone plate is attached with one main surface on the oblique end face of the metal shank, whereafter the other main surface of the precious stone plate is ground and provided with a sharp tip
10 and cutting edges.

2. Method according to claim 1, characterized in that a recess is cut out of the main surface of the precious stone plate to be attached to the metal shank.

3. Method according to claim 1 or 2, characterized
15 in that a titanium-copper-silver or gold-tantalum alloy is applied on the oblique end face of the metal shank and on the main surface of the precious stone plate to be attached thereon, whereafter both metalized faces are attached to each other at an increased temperature.

20 4. Microsurgical suture needle, obtained by the method according to claim 1, 2 or 3, characterized by a metal shank with a curved end part and a precious stone plate attached to the end face thereof extending obliquely with respect to its longitudinal axis, said precious stone plate having
25 main surfaces extending correspondingly obliquely with respect to its longitudinal rib, and said precious stone plate being provided with a ground tip and cutting edges.

5. Microsurgical suture needle according to claim 4, characterized in that a recess is provided in the precious
30 stone plate at the side of the metal shank.

6. Microsurgical suture needle according to claim 4 or 5, characterized in that the precious stone plate consists of diamond.

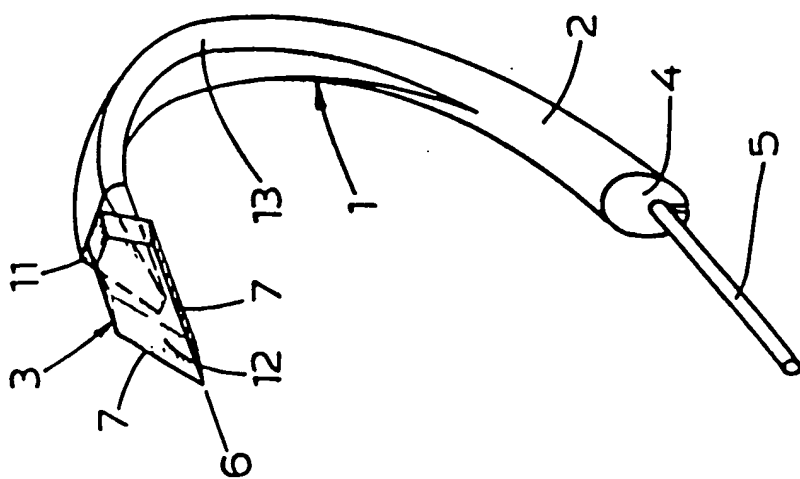


fig.1

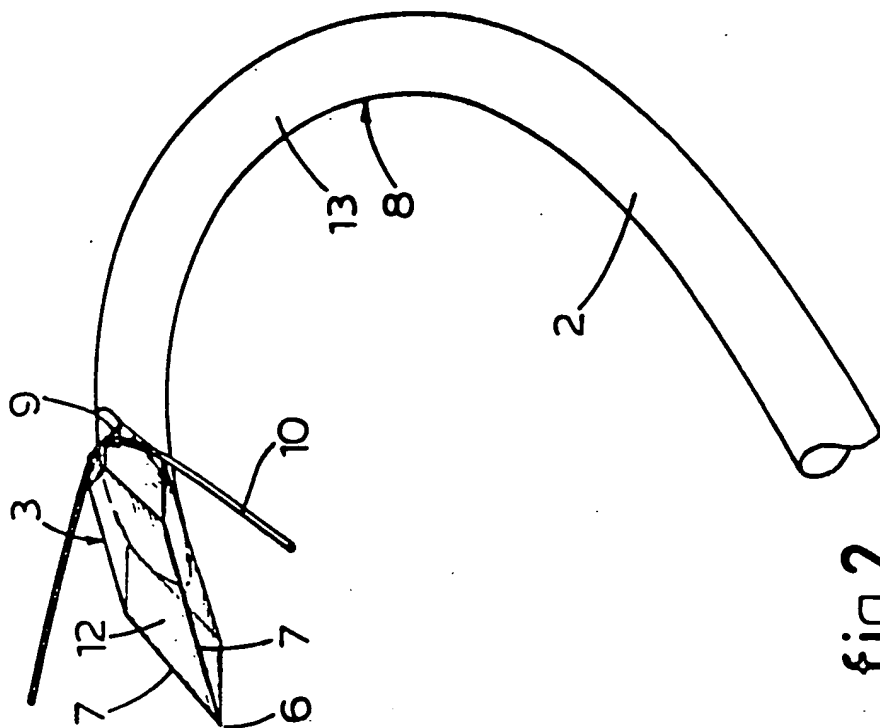


fig.2

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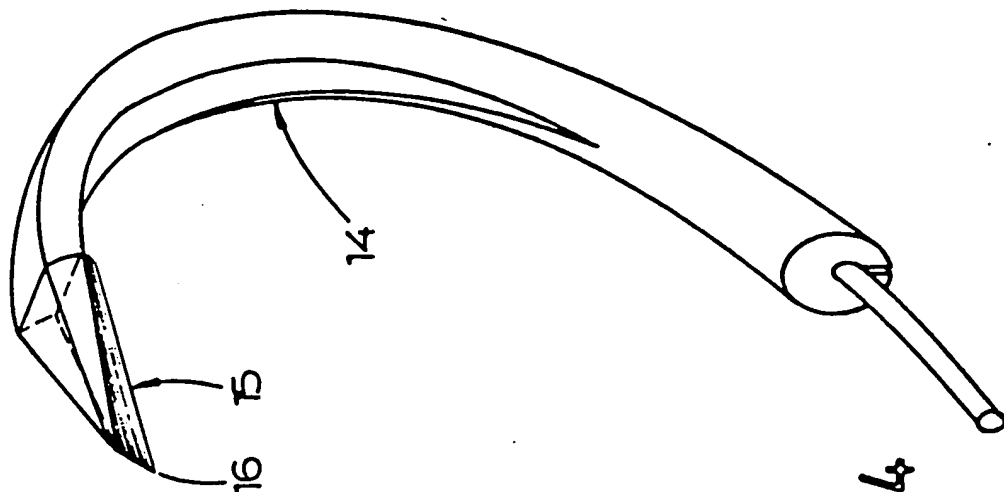


fig. 4

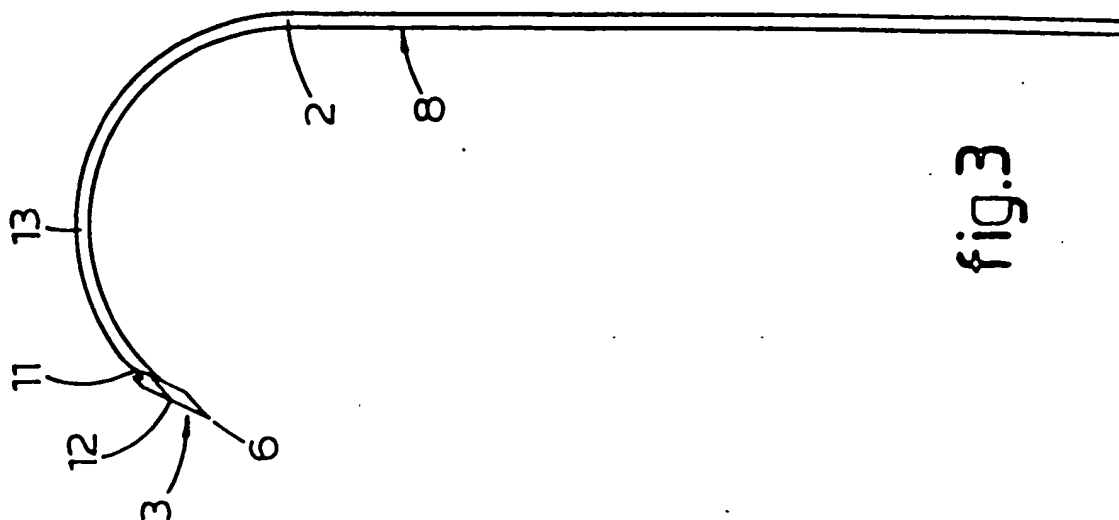


fig. 3



European Patent
Office

EUROPEAN SEARCH REPORT

0207545
Application number

EP 86 20 0984

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 4)
X	US-A-3 940 050 (JOHNSON et al.) * Column 1, lines 58-67 * ---	1-3	A 61 B 17/06 B 23 P 5/00
A	DE-A-3 118 673 (DUBOIS et al.) ---		
A	GB-A-2 091 624 (MACHEMER et al.) ---		
A	US-A-3 937 222 (BANKO) ---		
A	GB-A- 185 052 (SLATER) -----		
			TECHNICAL FIELDS SEARCHED (Int. Cl. 4)
			A 61 B B 23 P B 21 G
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 02-10-1986	Examiner GLAS J.

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87-001264/01 D22 DRUK- 21.06.85
DRUKKER D & ZN NV *EP -207-545-A
21.06.85-NL-001786 (07.01.87) A61b-17/06 B23p-05
Mfg. micro-surgical suture needle - by securing ground precious
stone plate to metal shank oblique end
C87-000494 E(AT BE CH DE FR GB IT LI LU NL SE)

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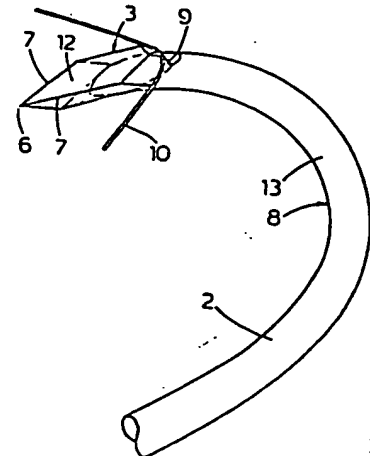
(E)ISR:-US3940050 DE3118673 GB2091624 US3937222 GB-185

Microsurgical suture needle is made by forming a precious
stone plate with main surfaces obliquely to a longitudinal rib
and grinding an end face obliquely to its longitudinal axis at
one end of a metal shank, to which the plate is then attached
by one main surface. The other main surface of the plate
is then ground and provided with a sharp tip and cutting
edges.

The plate is pref. of diamond and a recess is formed in it
on the side of the shank. A Ti-Cu-Ag or Au-Ta alloy is pref.
applied to the mating surfaces of plate and shank and the
coated surfaces are secured to each other at elevated temp.

USE/ADVANTAGE

E.g. for eye surgery. The needles are easier to handle
and are sharper and have more readily penetrating tips.
(10pp1358DAHDwgNo2/3)



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